

Work Order ID 66235

February 8, 2011 8:43:33 AM



Page 1

Item ID: D3531-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 2/08/11 Start Qty: 4.00



Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CL Date: 11/02/08 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3531

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3531 ☒ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary

6061 - 40

B 11-2-16

7

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 11-2-16

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

7

11-02-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66235

February 8, 2011 8:43:33 AM



Page 3

Item ID: D3531-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 2/08/11 Start Qty: 4.00



Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

7 BL 11-02-23

170

Identify as per dwg & Stock Location: G-A

0.00



Packaging

Memo

0.00

Packaging

GB 11/02/23 ⑦

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/23

C2 11/02/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 8, 2011 8:43:32 AM

Page 1

Work Order ID: 66235

Parent Item: D3531-1

Parent Item Name: Bracket



Start Date: 2/08/11

Required Date: 2/22/11

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-09-24 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.040

Purchased

No

100

sf

50.3300

0.3783

1.592842

2.7



1811-2-16

6061-T6 .040 Sheet

Location

Loc Qty

Loc Code

MAT21

50.33

111224

0.4

113004

49.93

113004

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	66235
Description: Bracket		Part Number:	D3531-1
Inspection Dwg: D3531 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.196	+0.005/-0.001	.194	✓		V B02	varies.
Ø0.129	+0.005/-0.001	.130	✓		V	varies.
0.33	+/-0.030	.333	✓		V	
2.840	+/-0.010	2.842	✓		V	
1.70	+/-0.030	1.696	✓		V	
1.45	+/-0.030	1.45	✓		V	
0.38	+/-0.030	.381	✓		V	
0.19	+/-0.030	.193	✓		V	
5.88	+/-0.030	5.881	✓		V	
12.66	+/-0.030	12.66	✓		T B01	
0.600	+/-0.010	.604	✓		V	
1.77	+/-0.030	1.77	✓		V	
1.24	+/-0.030	1.24	✓		V	
1.16	+/-0.030	1.16	✓		V	

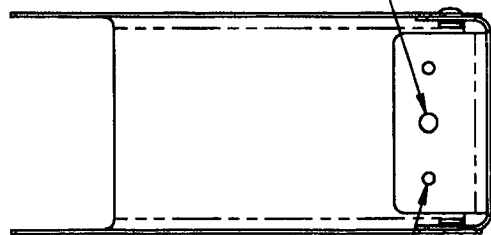
Measured by: IB	Audited by: [Signature]	Prototype Approval:	N/A
Date: 11-2-16	Date: 11-02-17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.15	New Issue	KJ/EC/DD	[Signature]



DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3531	REV. A SHEET 1 OF 3
DATE 07.06.19		TITLE BRACKET ASSEMBLY	SCALE 1:2
REV A	DATE 07.06.19	DESCRIPTION NEW ISSUE	

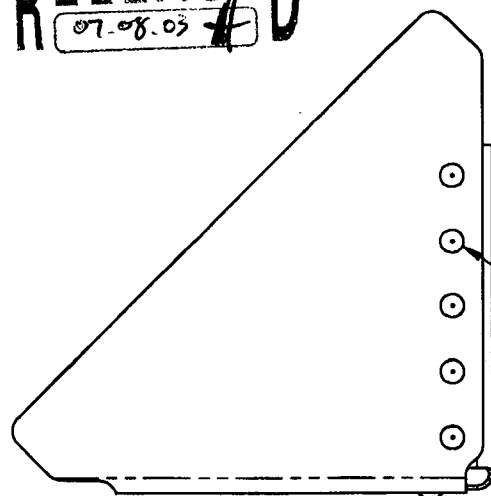
4
TRANSFER DRILL #9 ($\varnothing 0.196$)



TRANSFER DRILL #30 ($\varnothing 0.129$)
INSTALL MS20470AD4-4 RIVET
(2 PLACES)

4

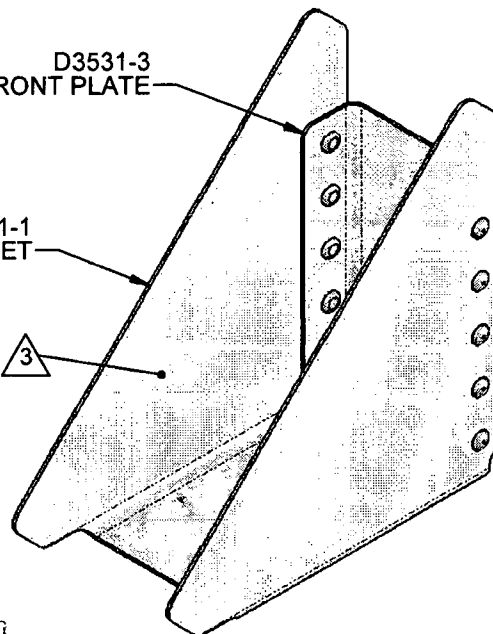
RELEASED
07.08.03



D3531-3
BRACKET FRONT PLATE

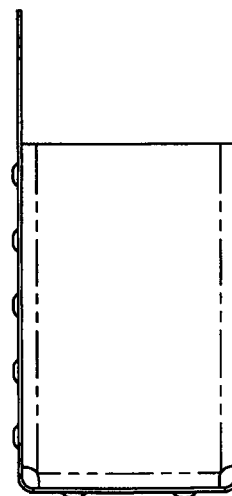
D3531-1
BRACKET

3



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NO. 66235
CZ1102108

MS20470AD4-4
(10 PLACES)



D3531-041 BRACKET ASSEMBLY

NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY BLACK
SANDTEX (4.3.5.7) PER DART QSI 005 4.3
ALL PARTS
- 2) ASSEMBLE PER DART QSI 003
- 3) IDENTIFY WITH DART P/N "D3531-041" USING
WHITE MARKER ON INSIDE OF BRACKET
ASSEMBLY, WHERE INDICATED
- 4) TRANSFER DRILL HOLES FROM D3531-1 BRACKET
THROUGH D3531-3 BRACKET FRONT PLATE
BEFORE FINISHING

PARTS LIST

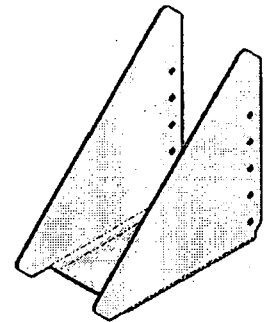
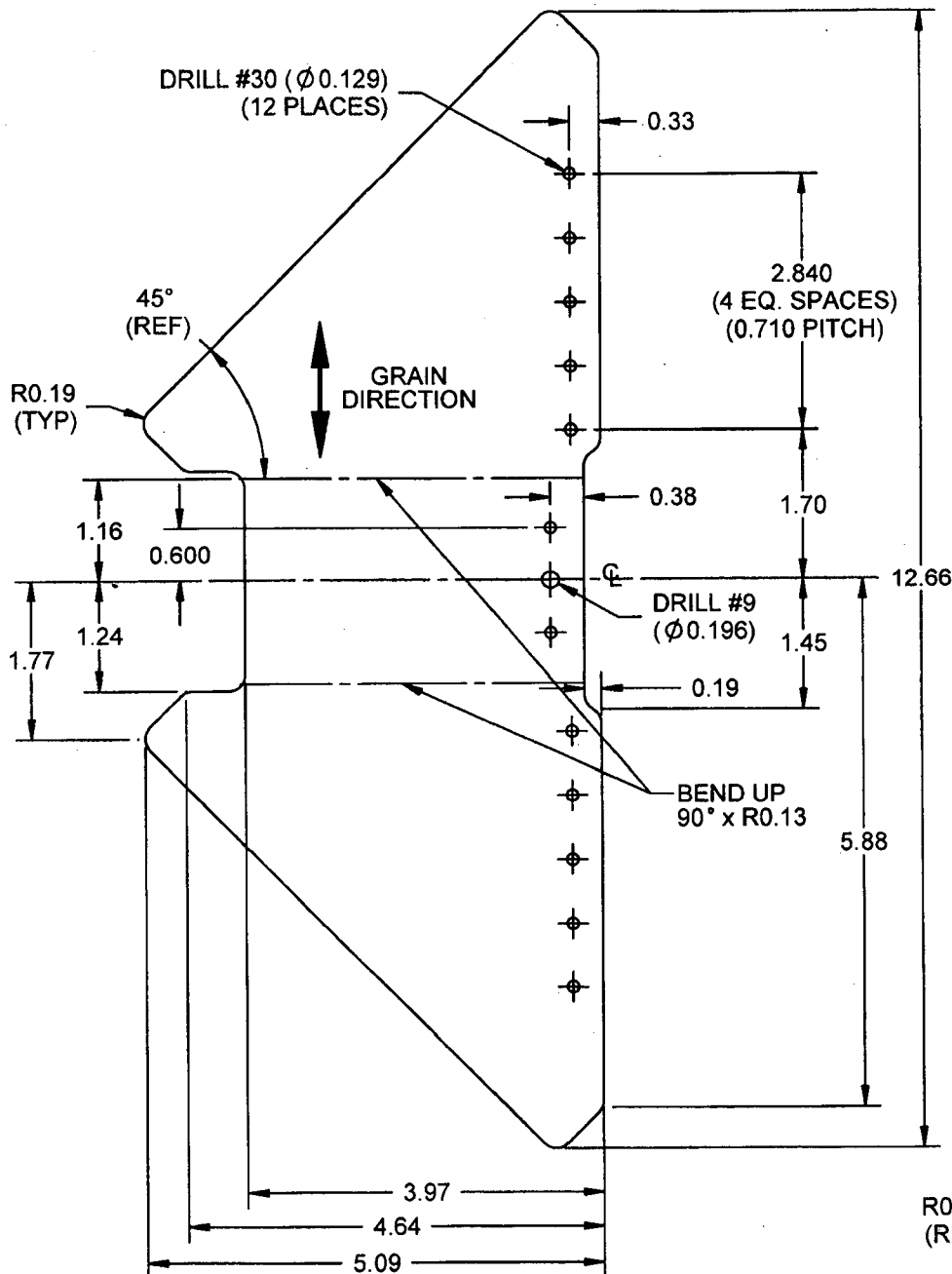
QTY.	P/N	DESCRIPTION
X	D3531-041	BRACKET ASSEMBLY
1	D3531-1	BRACKET
1	D3531-3	BRACKET FRONT PLATE
12	MS20470AD4-4	RIVET

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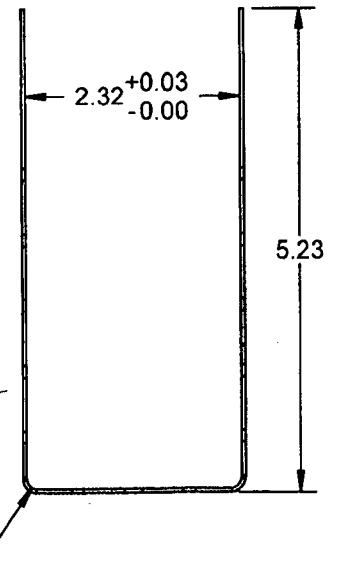
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DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED [Signature]	DRAWING NO. D3531	REV. A SHEET 2 OF 3
DATE 07.06.19	TITLE BRACKET ASSEMBLY		SCALE 1:2



RELEASED
07-08-03



D3531-1F FLAT PATTERN

D3531-1 BRACKET

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ

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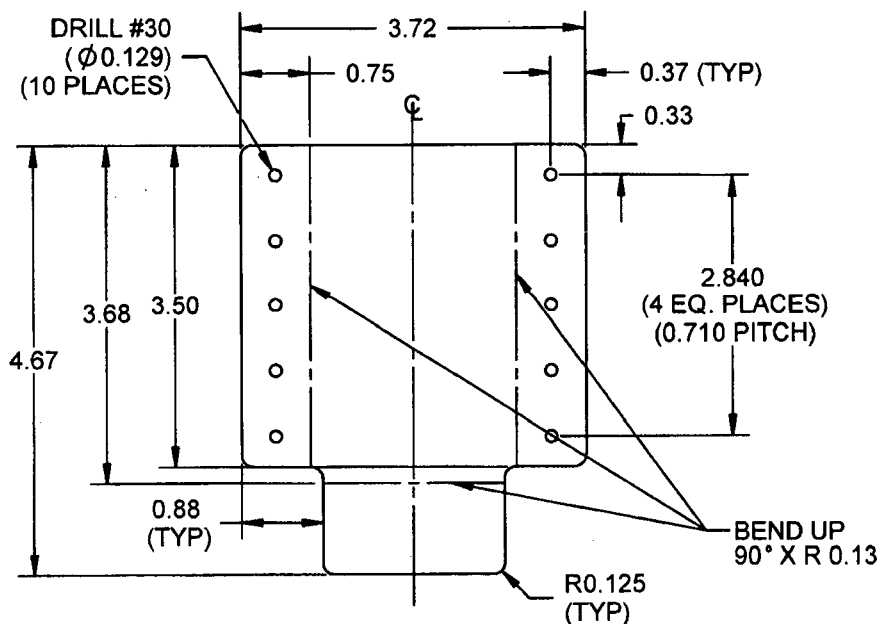
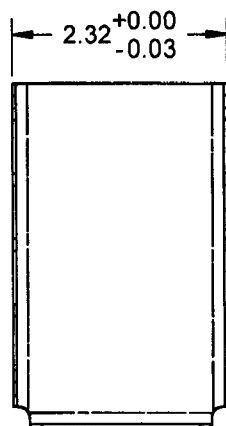
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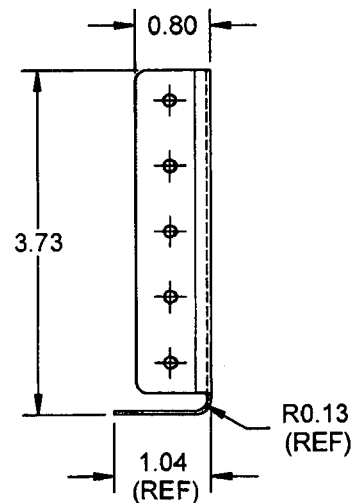
WORK ORDER
06235

DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED #	DRAWING NO. D3531	REV. A SHEET 3 OF 3
DATE 07.06.19		TITLE BRACKET ASSEMBLY	SCALE 1:2

**D3531-3F FLAT PATTERN**

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WITHOUT NOTICE
WORK ORDER
NO. 66235

**D3531-3 BRACKET FRONT PLATE****NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
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- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ

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